

this week



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2224
Job Sheet 194047



Part No: D2224

Job Qty: 6 pcs

Part Name: Rappel Anchor Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/10/19

Type: Stock

Description:

Note: DWG D2224 REV F IPP Rev D 02.04.23 Add note for grain direction & inspect 8, 21 NG IPP REV:E 18.10.26
AS PER DWG REV:F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	6 pcs	5/10/19	5/10/19	0.00	8.01	Bandsaw - 1	19-05-10
110	HAAS 5 Axis - B4B	6 pcs	5/10/19	5/10/19	0.37	8.01	HAAS - 5 - B4B	
120	QC 2	6 pcs	5/10/19	5/10/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	19-05-10
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

P.T.O.

1/4

NCR - 19-0242

Plex 4/25/19 10:38 AM Dart.lajeunesse.marie

130 QC 8	6 pcs	5/10/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	Amk 19/05/11
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Outsource - 4 - Anodize	6 pcs	5/10/19		ATG001-VC	8
150 Packaging 2-1 - Receive - B4B	5 pcs	5/10/19	0.00 0.00	Packaging 2 - 1 - B4B	2019-05-13
4,95				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	MAY 17 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	

160 QC 6	6 pcs	5/10/19	0.00 0.00	Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
170 Packaging 3-1 - Stock - B4B	6 pcs	5/10/19	0.00 0.00	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: 2.8" *****Note grain direction *****

Descriptions: 110 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine as per Folio D2224 & Dwg D2224

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: _____ Red Anodize as per Dwg D2224 MIL-A-8625

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC6- All purchased or subcontracted products) INSPECT ANODIZE

170 - (Identify as per dwg & Stock Location:_____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T73B2.500X03.25	7075-T73 Bar 2.50 X 3.25	1.5000 ft (.25 ea)	100-Bandsaw - 1	5643346
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B2.500X03.25	2	0	0
Part Specifications				
Specifications could not be found.				

MAT
used
0.947'

30.00
0.093'

4.000 x 4.000 L

Entered:

Date:

July 5, 2019

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7242

Route update only



Job: 194647		DISPOSITION		DEPARTMENT/PROCESS											
Part No. 12224		Rework ☐ Scrap ☒ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐					
Date: 12/5/27	Sequence #:	QTY Affected:		MIRB (QS1042)											
Description Work Order Deviation		Disposition													
Parts have cosmetic discoloration in endpiece. Stripping parts show no defect in aluminum. Re-modifying the parts. Re-modified parts have discoloration.		Acceptable.													
Root Cause		Lead hand / Supervisor													
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		QC / QA Coordinator DAS 68 9-89 MAY 27 2019													
FAULT CATEGORY															
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☒ Mislabeled ☐ Other/Details:				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☒ Part Lost/Missing ☐ Misread ☐			



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER
POHB043446



Supplier: ATG001-VC A.T.G. Industries Inc 731 INDUSTRIELLE ROAD ROCKLAND ON K4K 1T2 Canada Phone: 613-446-4544 Fax: 613-446-4556	PO No: POHB043446 PO Date: 5/13/19 Due Date: 5/17/19 Purchase Order Revision: Revision Date: Ship-To Contact: Phone:
Attention: Lalande, Marc-Andre	Via: Ground Pymt Terms: Net 30 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194047	D2224	Rappel Anchor Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O: Red Anodize as per Dwg D2224 MIL-A-8625	Firmed X4	-	5/15/19 MAY 17 2019	4 pcs	0 pcs	4 pcs	\$7.05/pcs	\$28.20
Line Item Note ****RUSH****											
2	193094	RBE350A94-5201-20	Cartridge, Dummy, Fuel (Outsource process- Anodize per QSI017 4.1.10.1), -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	5/17/19	23 pcs	0 pcs	23 pcs	\$7.05/pcs	\$162.15

DAS
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-89



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PURCHASE ORDER
POHB043446



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193431	C45-11-1	Sideplate, Solenoid Side (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	5/17/19	12 pcs	0 pcs	12 pcs	\$7.05/pcs	\$84.60
Grand Total:											\$274.95

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/14/19 1:55 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917813

Date: 15-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 each	Part: D2224 Rev: E Rappel Anchor Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (.4 - 1 mils). Job: 25117 Line: 1 PO: POHB043446		
23 ea	Part: RBE350A94-5201-20 Rev: 1A Cartridge, Dummy, Fuel Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (.4 - 1 mils)., Water Sealant Job: 25118 Line: 2 PO: POHB043446		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: MAY 15 2019 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED

MAY 17 2019

DART AEROSPACE LTD.

DAS
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9-89



Supplier Non-Conformance Report

Reviewed			
DQA:		Printed on: May 21, 2019	
Date:			
Details			
Raised Date 2019-05-31	Status Open	Owner Aboud, Robert	Number NCR19-7103
Target Date	Standard		Severity MINOR
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) atg		Fault Category Supplier\Quality
Details POHB043446 part D2224 job 194047 parts was received with marks showing thru the anodize.			
Keywords D2224, ATG, anodize		Product D205-523\D2224	
Document		Root Cause	
Closed By	Closed Date	Resolution	
Root Cause			
Target Date 2019-05-31	Owner Downing, Eric M	Closed Date	Closed By
Details			
Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
Corrective Action			
Target Date 2019-05-31	Owner Aboud, Robert	Closed Date	Closed By
Details			
Actions			

Number	Owner	Target Date	Completed Date
Details	Response		
1	Lavoie, Chantal	2019-05-23	
return part to supplier for rework.			

Implementing Corrective Action			
Target Date	Owner	Closed Date	Closed By
2019-05-31			
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details	Response		

Verification & Review			
Target Date	Owner	Closed Date	Closed By
	Downing, Eric M		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details	Response		